



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

6F9540V00231
Job Sheet 186761



Part No: 6F9540V00231

Job Qty: 1 ea

Part Name: AW169 Lower Cutter Installation Assembly

CONCESSION REQUIRED



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 1/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/8/19	1/8/19	0.00	0.00	Start Up Stores/Pkg-2	JAN 23 2019	69 DAS
100	Packaging	1 pcs	1/8/19	1/8/19	0.00	0.00	Packaging1-6	JAN 23 2019	69 DAS
105	QC	1 pcs	1/8/19	1/8/19	0.00	0.00	QC4	JAN 23 2019	69 DAS
120	Packaging	1 pcs	1/8/19	1/8/19	0.00	0.00	Packaging3-1	JAN 23 2019	69 DAS
125	DC	1 pcs	1/8/19	1/8/19	0.00	0.00	DC	JAN 23 2019	69 DAS
130	QC21-FG	1 Ea	1/8/19	1/8/19	0.00	0.00	QC21	JAN 23 2019	69 DAS

Part Op 120 - Identify and pack for shipping as per PPP 6F9540V00231

Descriptions: 125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation
D169-841-015	AW169 Lower Cutter	1 Ea (1 ea)	90-Start up Operation

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D169-841-015	1	0	0

Part Specifications

Specifications could not be found.



1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 11/21/18 9:12 AM Dart.lajeunesse.marie

Container No: S147079



Part: 6F9540V00231

Job No: 186761

Serial No/Batch: S147079

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 01/23/19

concession

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																
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LEONARDO HELICOPTERS		Supplier Concession				PAGE 1 of 2	PLANT Vergiate	
Supplier NC N.	AWC-013/00	Date	28.01.2019	AW Concession	400000079574	Purchase Order	4801861243	
P/N	6F9540V00231			Grade/Category	NC	Drawing Issue		
Part Description	PROTECTR, CCP ASSY LOWER			Batch Quantity	4,000	Defective Quantity	4,000	
AW NC	MARCO FRANCESCONI					A/C Type/Model	AW6	
Supplier	DART AEROSPACE LTD					Contract		
Defect MA01 - Items or materials different from requir - S/N S147044, S147074, S147077, S147079 * 28.01.2019 17:40:26 MARCO FRANCESCONI (39978) * SEE SUPPLIER ATTACHED DOC. AWC-013 Cause of Defect								
					Repetitiveness (same P/N - Defect Code)	NO ☐	YES ☒	Follow (5)
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist inputs: * 04.02.2019 18:51:07 MARCELLO STEFANELLI (9273) * Accettable to use as is, as for evaluation in the annex.				Investigation Report n.		Compliance Report n.		
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B								
Defect effect					Limitations			
	Before Repair		After Repair					
Safety	☐ YES		☐ YES ☐ NO		☐ YES (to specifity) ☒ NO			
Life or Duration	☐ YES		☐ YES ☐ NO					
Strenght	☐ YES		☐ YES ☐ NO					
Performances	☐ YES		☐ YES ☐ NO					
Interchangeability	☐ YES		☐ YES ☐ NO					
Reliability	☐ YES		☐ YES ☐ NO					
Maintainability	☐ YES		☐ YES ☐ NO					
Installability	☐ YES		☐ YES ☐ NO					
Testability	☐ YES		☐ YES ☐ NO					
Only Appearance	☐ YES		☐ YES ☐ NO					
No Effect	☒ YES		☐ YES ☐ NO					
Repair Proposal:					Decision			
					☐ Use rep. with spec.repair(not yet applied) ☐ Use repaired with known repair(yet applied) ☒ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO		
Mark part with Concession		☒ NO ☐ YES		Method :				
ATE	MARCELLO STEFANELLI			CPE			Date	04.02.2019
Checks and tests to be performed								
Repair registration		with repair WO ☐ Number:						
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	
S147044	☒	☐	☐		☐	☐	☐	
S147074	☒	☐	☐		☐	☐	☐	
S147077	☒	☐	☐		☐	☐	☐	
S147079	☒	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)	4,000	Use Repaired (Q.ty)		Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI			MARCO FRANCESCONI				
Date	04.02.2019			05.02.2019				

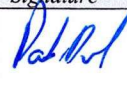
Supplier NC N.	AWC-013/00	Date	28.01.2019	AW	400000079574	Purchase Order	4801861243
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DEFECT 0001 MA01 Items or materials different from requir
S/N S147044, S147074, S147077, S147079

*

DEFECT CAUSES

* C41 Material did not comply with specificati

 AgustaWestland A Finmeccanica Company		CONCESSION				Pag. 1 of 2	
<i>Manuf. Doc. N.</i>	AWC-013	<i>Date</i>	Jan 25. 2019	<i>AW Doc. N.</i>	400000079574	<i>Purchase Order</i>	4801861243
<i>AW P/N</i>	6F9540V00231	<i>S/N / Batch Number</i>	S147077 S147079 S147044 S147074	<i>Grade</i>	A	<i>AW Drawing Issue</i>	B
<i>Description</i>	Protector, CCP Lower Assembly			<i>Batch Q.ty</i>	4	<i>Defective Q.ty</i>	4
<i>Manufacturer</i>	Dart Aerospace LTD			<i>Model</i>	AW169		
<i>Defect(s) Description</i>							
The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), P/N 6F9540V0231. Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.							
				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
				<i>Quality Assurance</i>	DAS 9 9-89 DAS-16-9-89	 P. Duval	Jan 25, 2019
<i>Defect(s) Cause</i>							
Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.							
				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
				<i>Quality Assurance</i>	DAS 9 9-89 DAS-16-9-89	 P. Duval	Jan 25, 2019
<i>Corrective Action</i>						<i>Complete Before</i>	
Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1							
				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
				<i>Quality Assurance</i>	DAS 9 9-89 DAS-16-9-89	 P. Duval	Jan 25, 2019

For "MANUFACTURER" SUPPLIERS ONLY

ENGINEERING evaluation and proposal

Engineering evaluation

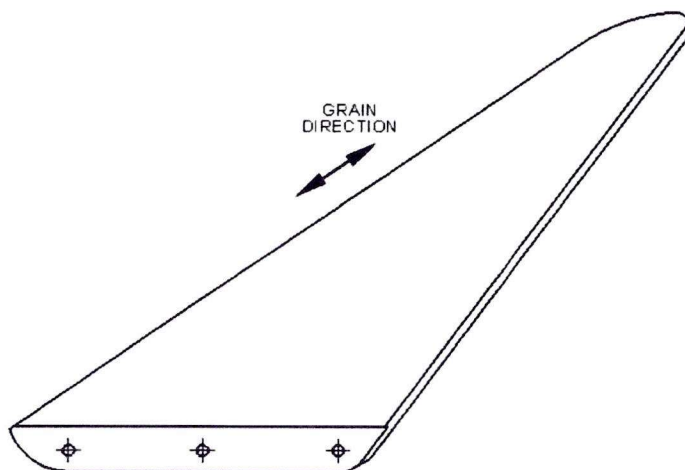
Investigation report

n: NCR18-6764

Compliance report

n...N/A.....

Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



Defect effects			Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap
Concession Classification	☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no